

Work Order ID 73923

Monday, September 19, 2011 12:35:48 PM

Page 1

Item ID: D350-748-201

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011 Start Qty: 1.00

Required Date: 10/14/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-748-241

F

100

0.00



DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile & type labels per PPD D350-748-201 CHG002

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

CNC Alpha 160 Bender

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

Quality Control

12-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Stress relief

Heat treat crosstube as per QSI010 4.3

Temp: 375Start time: 4h30Finish time: 8h30

①

SAD 12-01-20

127

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Memo

0.00

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube

Batch: M110 779

MO

12/1/24

MO

12/1/24

MO

12/1/25

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

12 01 25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 15990
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

CL 12/01/23 ①

Pho 7

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

CL 12/3/23 ①

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 12.01.24 AUTH af

RELEASED DATE

FOR CRUSHING

W/O:		73923						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: D38-748-701 PAR #: Fault Category: Landing gear / components NCR: Yes No DQA: Date: 12/03/16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 12/3/16

NCR: <u>12-1244</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/3/12	150	tune broke / cracked while at cad platten R.C. Pous.	<u> </u> 12/03/12 P. J. 12/2	Scrap + Destroy no Reptze.	MO 12/3/13	<u> </u> 12-3-13	<u> </u> 12/03/12 stay 2	

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN- LBS								

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
220 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							
230 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

0.00



Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPPD350-748-201

Location: _____

PPP Rev: _____

250

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

1203-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, September 19, 2011 12:35:55 PM

Work Order ID: 73923



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-241TRN		Manufactured	No			110	Each	9.0000	1	1			
Crosstube Turning Detail													

Location Loc Qty Loc Code

LG	8	
61314	0	
61315	0	
68838	1	
68839	1	
68841	1	
70654	1	
72330	1	
72331	1	
72332	1	
72333	1	
LG003	1	
68840	1	

ALS4-1032-225

Purchased

No

200

Each

1,883.000

1

1



Insert

Location Loc Qty Loc Code

ST282	1883	
110768	62	
117717	9	
118386	860	
118696	952	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, September 19, 2011 12:35:55 PM

Work Order ID: 73923

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

200 Each

0.0000 1 1



Washer

D2856-400 Manufactured No

200 f

208.9845 1.181 1.243158



Abraison Strip

Location

Loc Qty

Loc Code

ST403

0.3149

68076

0.3149

ST409

208.6696

63735

0.6696

71164

208

1- cut as per dwg D2856

D3502-1 Manufactured No

200 Each

43.0000 2 2



Support

Location

Loc Qty

Loc Code

ST063

43

61206

7

64004

10

68951

12

72129

14

MS21920-20 Purchased No

200 Each

74.0000 2 2



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

74

116799

10

118236

18

118649

46

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, September 19, 2011 12:35:56 PM

Work Order ID: 73923

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

200

Each

295.0000

1

1



Screw

LocationLoc QtyLoc Code

ST290

95

117441

95

ST291

200

118612

200

AN4-41A

Purchased

No

220

Each

309.0000

8

8



Bolt

LocationLoc QtyLoc Code

ST360

309

115108

34

115705

50

116191

50

117619

50

117795

25

118451

50

118838

50

AN4-6A

Purchased

No

220

Each

1,216.000

16

16



Bolt

LocationLoc QtyLoc Code

ST356

1200

117872

200

118422

300

118628

400

118838

300

ST358

16

117514

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, September 19, 2011 12:35:56 PM

Work Order ID: 73923

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-32A Purchased No 220 Each 172.0000 4 4



Bolt



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	50	
118628	50	
ST340	122	
117161	1	
117872	60	
118191	11	
118422	50	

AN960JD416 NAS1149D0463J Purchased No 220 Each 0.0000 32 32



Washer

AN960JD516 NAS1149D0563J Purchased No 220 Each 0.0000 8 8



Washer

D3500-1 Manufactured No 220 Each 16.0000 4 4



Saddle

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST424	9	
66127	9	
ST424/25	7	
62207	7	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/19/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3501-1 Manufactured No 220 Each 245.0000 16 16



Bushing

LocationLoc QtyLoc Code

ST063

202

68939

102

70682

100

ST066

43

67757

43

MS21042L4 Purchased No 220 Each 4,317.000 24 24



Nut

LocationLoc QtyLoc Code

ST300

4317

117441

51

117601

637

117885

629

118451

2000

118927

1000

MS21042L5 Purchased No 220 Each 1,287.000 4 4



Nut

LocationLoc QtyLoc Code

ST300

1287

116105

5

116548

53

117441

343

117611

90

118179

496

118910

300

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

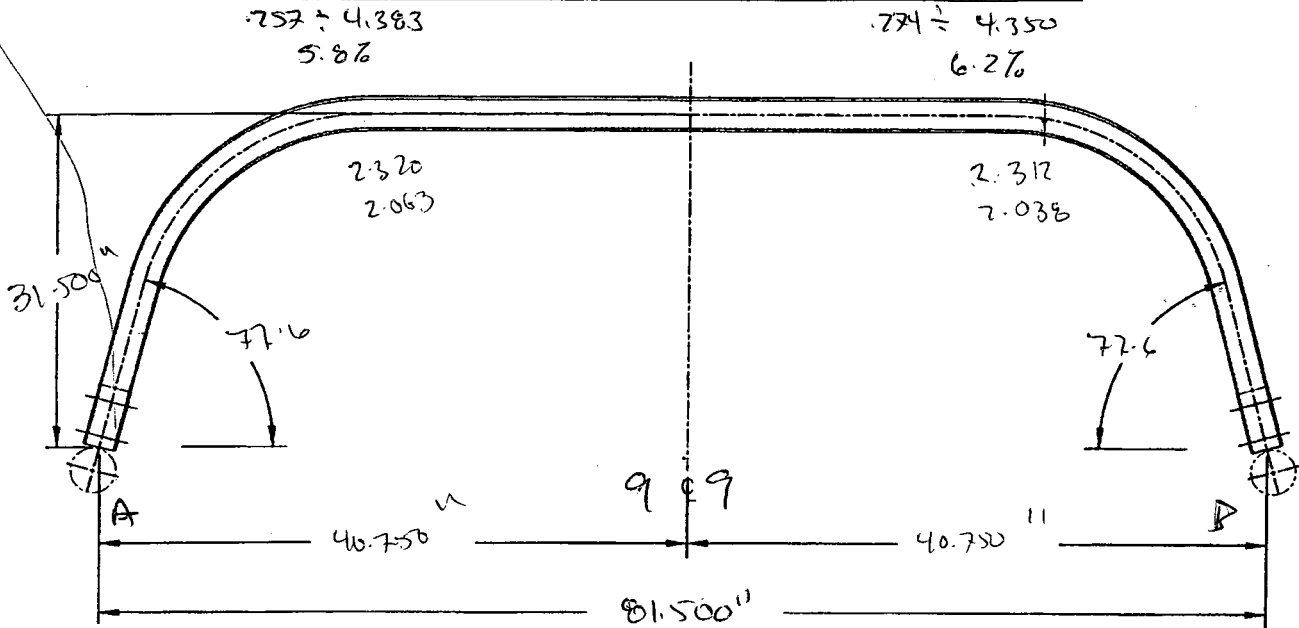
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73929
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments	
twist = .154"	
Size A = 5.8%	crack @ 7 passes
Size B = 6.27%	crack @ 9 passes

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

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WORK ORDER
NO. 73923

211-09-29

RELEASED
2011-01-08
MP

F	ADD HRC TEST OPTION (B8-1) PER PAR 08-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>		
DRAWN	<i>qp</i>		
CHECKED	<i>qp</i>		
MFG. APPR.	<i>qp</i>		
APPROVED	<i>qp</i>		
DE APPR.	<i>qp</i>		
DATE	10.11.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. F	
D350-748-241			SHEET 1 OF 4
TITLE		SCALE	
CROSSTUBE (AS 350/355 HI AFT)			NTS
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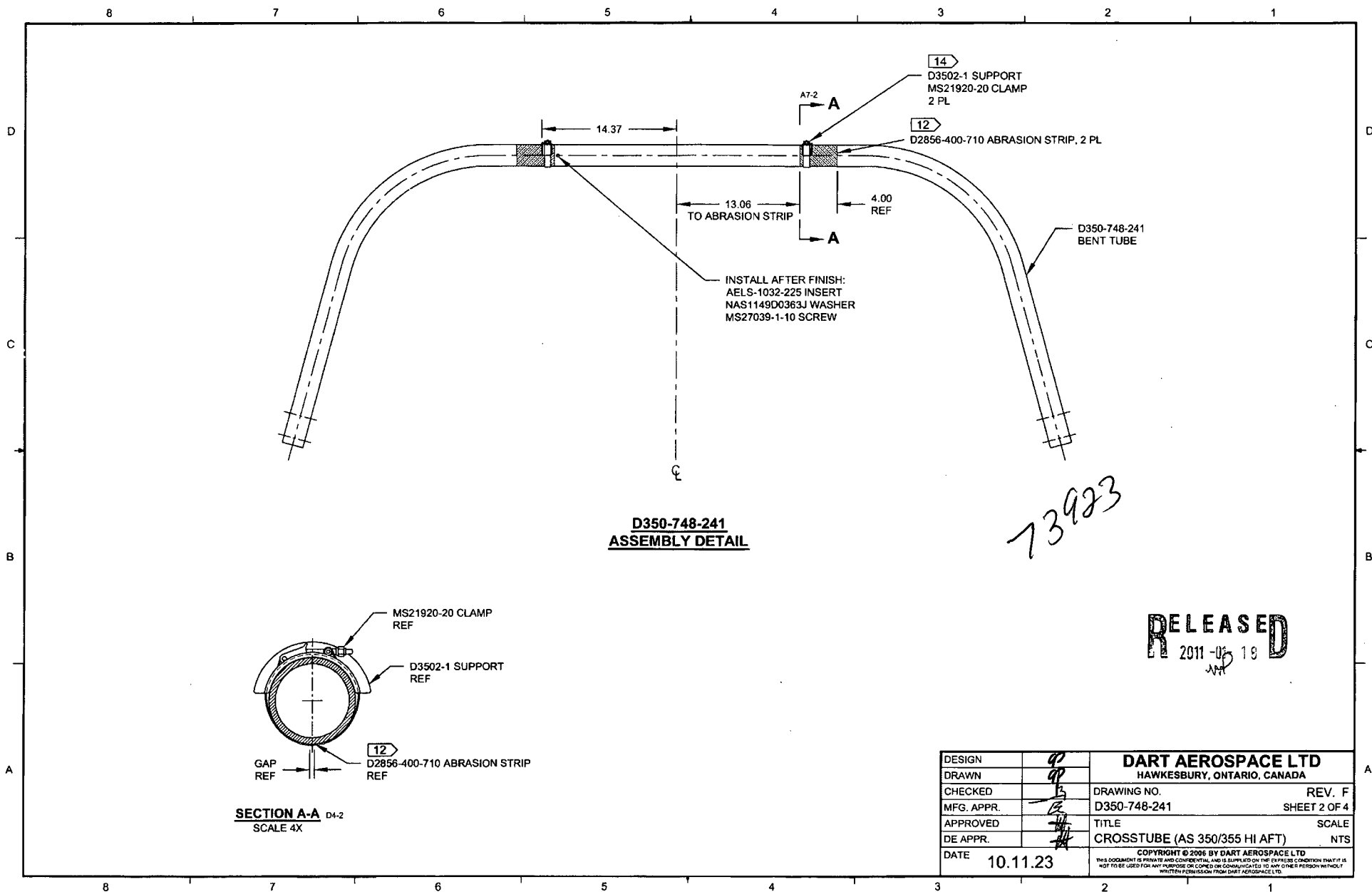
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



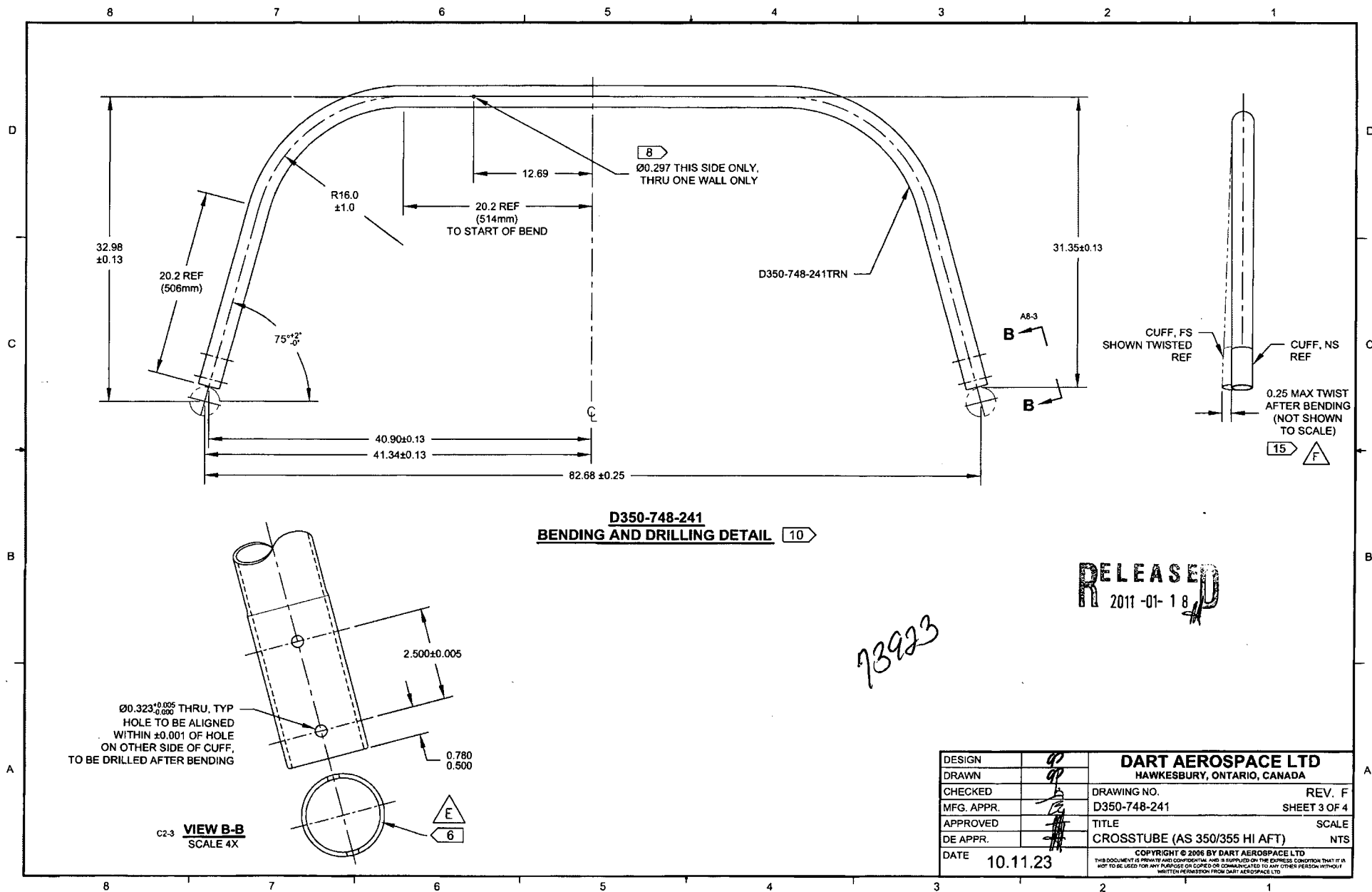
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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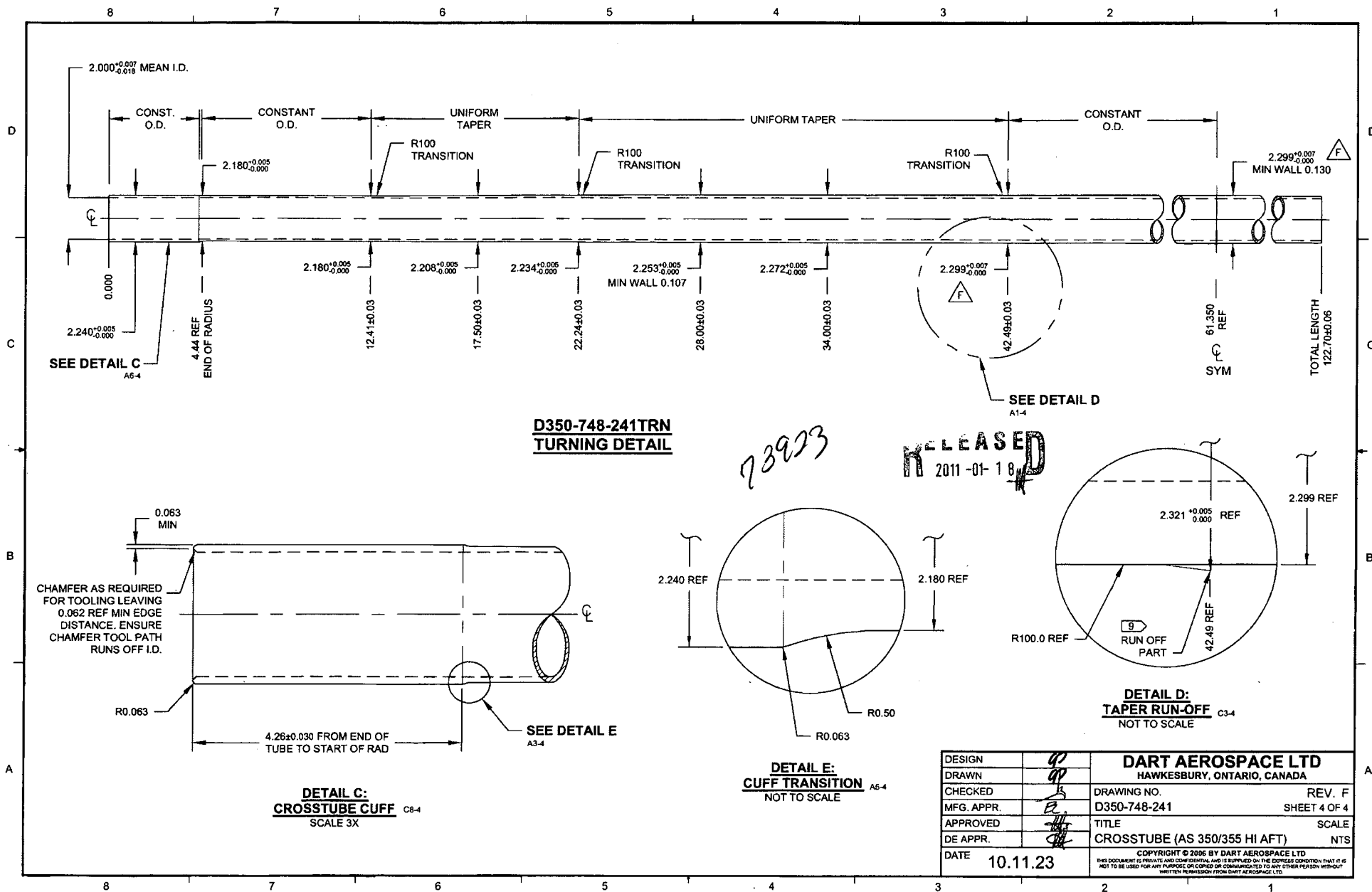
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

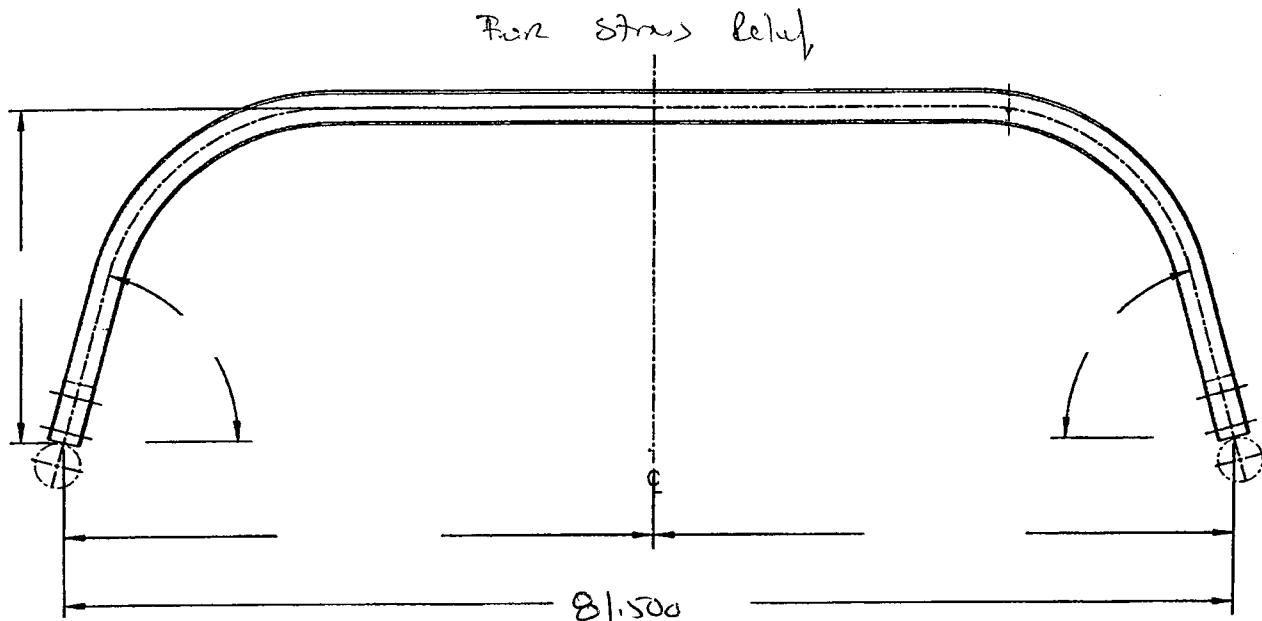
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73929	
Description: Crosstube High Aft (AS350/355)		Part Number: D350-748-201	
Inspection Dwg: D350-748-241		Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
tw. sh = 154"

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Feb-24-2012

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 111683
INVOICE #: 59166

**CONTRACT OR
PURCHASE ORDER #** PO15990

DESCRIPTION: SKID

QTY 1

P/N # d350-748-101

S/N # 73923

STRESS RELIEVE BAKE HEAT CHART # 12-132. MPI IAW ASTM-E-1444. CADMIUM PLATE IAW AMS-QQ-P-416C TYPE 2 CLASS 2.
BAKE HEAT CHART # 12-170. MPI IAW ASTM-E-1444.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:

